

Work Order ID 164709***164709***

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Friday, July 28, 2017 8:34:59 AM

Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Chaffing Shield
Start Date: 7/24/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan:  Date: JUL 28 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3189	D
D412-664-243	F

100

0.02

100

SHEAR

Waterjet

Memo

0.13

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary



17/07/28

DAS
40
9-89

103

0.00

103

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.04

Quality Control



17/07/28

DAS
40
9-89

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 *105* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				<u>4</u>			DAS 38 9-89 JUL 31 2017
110 *110* Small Fab Small Fab	Small Fab Memo 1- Roll as per Dwg D3189	0.00 0.19			DAS 30 9-89	<u>(4)</u>			AUG 01 2017
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				<u>4</u>			DAS 38 9-89 AUG 01 2017

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Friday, July 28, 2017 8:35:00 AM

Item ID: D3189-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Chaffing Shield
 Start Date: 7/24/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/28/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124 *124* HandFinish Hand Finishing	Memo APPLY A THIN LAYER OF PROSEAL 890 TO CONCAVE SURFACE. (REF: AS PER DWG D412-664-243 (NOTE 15) A/R PROSEAL 890 BATCH: <u>137495</u> 1/18	0.00 0.12				<u>6</u>			<u>DX. 1A8</u> <u>17-08-21</u>
127 *127* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<u>6</u>			<u>DAE</u> <u>38</u> <u>9-89</u> <u>AUG 25 2017</u>
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ <u>LOCATION : LG051</u>	0.00 0.04				<u>4</u>		<u>AUG 28 2017</u>	<u>DAE</u> <u>6</u> <u>9-89</u>

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							
Quality Control									

17/9/5 JH

11708.29

Picklist Print

Friday, July 28, 2017 8:34:57 AM

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Work Order ID: 164709

164709

Parent Item: D3189-1

D3189-1

Parent Item Name: Chaffing Shield

Start Date: 7/24/2017

Required Date: 7/28/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B05.08.22 No longer made in-house KJ/JLM
IPP Rev: C 06-03-24 Rolling Now made in House JLM
IPP Rev: D 07-04-16 As per Rev B JLM
11.05.11 now made on waterjet DD verf: JLM
AS PER DWG REV.D DD VERF: JLM
IPP Rev: E
IPP REV: F 14.02.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased		No		100	sf	20.1700	0.32	1.347368			DAS
M304S24GA									**			17/07/28	40
304/316 .025 Sheet													9-89

Location

MAT020

Loc Qty

20.17

Loc Code

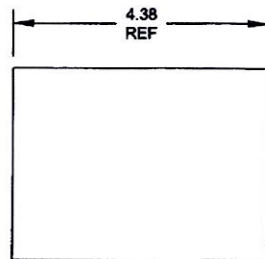
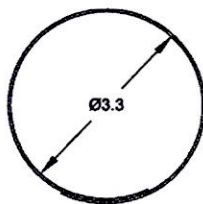
m135780

2.97

m136896

17.2

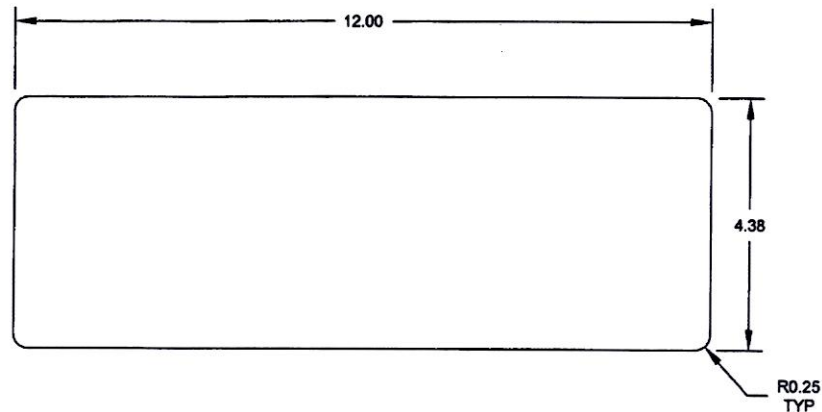
1.4



D3189-1 CHAFING SHIELD
(ROLL D3189-1F AS SHOWN)

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 24 GAUGE (0.025" THICK REF)
PER MIL-S-5059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF. DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs



D3189-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164709
JUL 28 2017

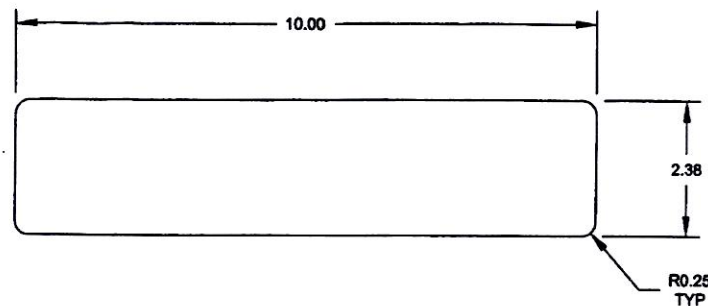
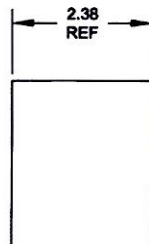
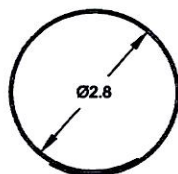
RELEASED
2014-02-10
WJP

D	24GA WAS 25GA (PAR 14-326)	CP	14.01.07
C	-1/3 ENLARGED TO REDUCE CHANCE OF DMG TO CROSSTUBE, ALL FILLETS INCREASED TO R0.25	CP	12.08.14
B	ADD -3	CP	07.01.05
A	NEW ISSUE	CP	03.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.01.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D
D3189 SHEET 1 OF 2
TITLE SCALE
CHAFING SHIELD NTS

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D3189-3F FLAT PATTERN

D3189-3 CHAFING SHIELD
(ROLL D3189-3F AS SHOWN)

RELEASED
2014-02-10

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 24 GAUGE (0.025" THICK REF)
PER MIL-S-5059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF. DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs



DESIGN	<i>g</i>	DART AEROSPACE LTD	
DRAWN	<i>g</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3189	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CHAFING SHIELD	NTS
DATE	14.01.07	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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